

Work Order ID 131915

Tuesday, April 21, 2015 1:56:34 PM

131915

Page 1

Item ID: D4149-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft X-Tube Lug Ass'Y
 Start Date: 4/20/15 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 4/20/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: 15-04-22 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4149	C

100		0.00							
100									
Small Fab	Memo	0.00							
Small Fab	1- Assemble as per dwg								

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									

120	Identify as per dwg & Stock Location: <u>ST539</u>	0.00							
120									
Packaging	Memo	0.00							
Packaging									

4X 15/05/12 9-89 DAS 36

9 MAY 12 2015 DAS 30 9-89

4 27 MAY 12 2015 DAS 27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

MLJ MAY 15 2015

MLJ MAY 14 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

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Work Order ID: 131915

131915

Parent Item: D4149-041

D4149-041

Parent Item Name: Aft X-Tube Lug Ass'Y

Start Date: 4/20/15

Required Date: 4/20/15

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC

IPP Rev:B 10.07.22 as per revB DD verf:JLM

11.03.03 as per revC DD verf:JLM

IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21043-3		Purchased	No			100	Each	992.0000	4	8			
MS21043-3									**			15/04/28	DAS 36 9-89
Nut													
				<u>Location</u>				<u>Loc Qty</u>					
				FG				80					
				103691				80					
				FP001				88					
				m130673				88					
				GA				367					
				m130673				15					
				m131677				352		8			
				ST304				457					
				m131340				457					
MS21043-4		Purchased	No			100	Each	1,083.000	1	12			
MS21043-4									**			15/04/28	DAS 36 9-89
Nut													
				<u>Location</u>				<u>Loc Qty</u>					
				FG				40					
				104603				40					
				GA				370					
				m128798				370		12			
				ST304				673					
				m128818				34					
				m131697				639					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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D4149-041

Parent Item Name: Aft X-Tube Lug Ass'y

Start Date: 4/20/15

Required Date: 4/20/15

Start Qty: 4.00

Required Qty: 4.00

DAS
36
9-89

D3910-1 Manufactured No

100 Each 30.0000 1 4

D3910-1

Crosstube Lug

**

15/04/28

Location

Loc Qty

Loc Code

ST524

30

128844

30

4

D4091-1 Manufactured No

100 Each 1.0000 1 4

X D4091-1

D4091-1

Mounting Lug

**

15/05/12

DAS
36
9-89

Location

Loc Qty

Loc Code

ST522

1

128425

1

1

D4149-1 Manufactured No

100 Each 4.0000 2 8

D4149-1

D4149-1

Crosstube Lug Plate, Aft

**

15/04/28

DAS
36
9-89

Location

Loc Qty

Loc Code

ST094

1

125697

1

ST103a

3

129949

3

1

D4149-3 Manufactured No

100 Each 5.0000 1 4

D4149-3

D4149-3

Spacer

**

15/04/28

DAS
36
9-89

Location

Loc Qty

Loc Code

ST094

5

129900

5

4

DQA: _____ Date: _____



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Required Date: 4/20/15

Start Qty: 4.00

Required Qty: 4.00

D4149-5 Manufactured No

100 Each 18.0000 1 4

D4149-5

Eyebolt Stud

DAS
36
9-89

15/04/28

Location

Loc Qty

Loc Code

ST103a

18

122937

4

129781

2

130604

12

4

AN3C12A Purchased No

100 Each 250.0000 2 8

AN3C12A

Bolt

DAS
36
9-89

15/04/28

Location

Loc Qty

Loc Code

GA

171

M128727

171

ST349

79

M128727

79

8

AN4C13A Purchased No

100 Each 46.0000 3 12

AN4C13A

BOLT

DAS
36
9-89

15/04/28

Location

Loc Qty

Loc Code

ST344

46

131677

38

m128818

8

12

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		OTHER : _____																																																																			

Picklist Print

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Work Order ID: 131915

131915

Parent Item: D4149-041

D4149-041

Parent Item Name: Aft X-Tube Lug Ass'y

Start Date: 4/20/15

Required Date: 4/20/15

Start Qty: 4.00

Required Qty: 4.00

MS20615-4M18

Purchased

No

100

Each

551.0000

3

12

DAS

MS20615-4M18

Rivet

**

15/04/28

36

9-89

Location

Loc Qty

Loc Code

CCK003

378

m123810

370

GA

74

m130358

74

ST307

107

125162

107

12

NAS1149C0332R

Purchased

No

100

Each

4,434.000

4

16

DAS

NAS1149C0332R

WASHER

**

15/04/28

36

9-89

Location

Loc Qty

Loc Code

FP001

2174

123248

34

m130325

2140

GA

726

m131618

726

ST260a

1510

m131697

1510

ST271

24

m131340

24

16

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

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Page 5

Work Order ID: 131915

131915

Parent Item: D4149-041

D4149-041

Parent Item Name: Aft X-Tube Lug Ass'y

Start Date: 4/20/15

Required Date: 4/20/15

Start Qty: 4.00

Required Qty: 4.00

NAS1149C0432R

Purchased

No

100

Each

3,551.000

6

24

NAS1149C0432R

DAS
36
9-89

WASHER

15/04/28

Location

Loc Qty

Loc Code

GA

2238

m125807

476

m131467

1762

ST271

1313

m131452

1313

28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
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